

V/PTS

Description

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Method and apparatus for controlling the cut register of a web-fed rotary press

10 The invention relates to a method and an apparatus for controlling the cut register of a web-fed rotary press.

In web-fed rotary presses, it is known to use an actuating roll which can be displaced in linear guides as an actuating element for cut-register control, using
15 which actuating roll the paper path length between two pulling units is changed and the register error is thus corrected. Register rolls of this type are shown, for example, in DE 85 01 065 U1. The adjustment is generally carried out by means of an electric stepping
20 motor. Apparatuses of this type are associated with relatively great mechanical and electrical complexity.

It is an object of the invention to provide a simple method for controlling the cut register. Furthermore,
25 an apparatus is to be provided which is distinguished by low mechanical and electrical complexity.

The object is achieved by the features of the independent claims. The solution does not require any
30 additional mechanical web-guiding element. For cut-register correction, non-printing pulling units which are already present are used, such as the cooling unit, pull rolls in the folder superstructure, the former roll or further pulling units which lie on the web path
35 between the last printing unit and the knife cylinder.

The linear register roll, in particular, with the stepping motor and associated actuation electronics is dispensed with as a result of the variable-speed individual drives on the pulling units.

As a consequence of the particular properties of the control system, the cut-register control is dynamically faster than in the conventional solution by means of a register roll, as a change in the lead of the relevant pulling unit replaces a path change.

The parameters which are incorporated into the cut-register control system are largely independent of the properties of the rotary press. Furthermore, the cut-register accuracy can be increased substantially by the new method.

In the method as claimed in the invention, the running time of the web image points with a constant web path is adjusted whereas, in the prior art, a change has been made to the web length at a constant web speed.

The cut register is corrected by the adjustment of the lead of a non-printing pulling unit between the last printing unit and the knife cylinder. This correcting variable influences the cut-register error, as seen in stationary operation, proportionally to the length of the free web between the engaging, non-printing pulling location and the pulling location lying ahead of it.

The register control system is of an order one lower than in the conventional control with an actuating roll, on account of the fact that it is not an angle or a path but a speed which has to be adjusted. As seen

in control technology terms, there is a good approximation of an aperiodic PT2 path.

5 A PI controller can therefore be used as a register controller. A subordinated web tension control means can additionally be provided.

10 The actuation time of the closed register control circuit depends only on the sum of the small time constants of the register control system. The web time constant is either compensated for by the adjusting time of the PI register controller, or other optimization criteria of control technology are used. As the rotational-speed control circuit is dynamically
15 very fast, the register control using the novel method is substantially faster than in the conventional solution with a register roll.

20 The invention is to be explained in greater detail in the following text using an exemplary embodiment. The single figure shows an apparatus for controlling the cut register in a web-fed rotary press, the pulling unit Z3 being used as the actuating element by way of example.

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The figure shows the path of a web 1 from a last printing unit 2 via a pulling unit Z1 in the form of a cooling unit 3, a pulling unit Z2 ahead of a turning unit 4, a pulling unit Z3 after the pulling unit 4, and
30 a pulling unit Z4 ahead of a folding unit 5. In the folding unit 5, the web 1 is cross-cut by means of a cross-cutting device 6, for example by means of a pair of cutting rolls. Each pulling unit Z1 to Z4 is driven by a motor 7.1 to 7.4 with an associated motor control
35 means.

The motor 7.3 of the pulling unit Z3 is connected to the output of a controller 8 to whose input a cut-register sensor 9 is connected. Moreover, a further cut-register sensor 10 is connected to the controller 8, which further cut-register sensor 10 is arranged on a web section which is situated at a further pulling unit arranged ahead of the pulling unit Z3 in the web running direction. It is thus also possible for the cut-register 10 which is situated ahead of the pulling unit Z2 to be arranged on the web section between the last printing unit 2 and the cooling unit 3. Furthermore, the controller 8 is connected to the motor 7.4 of the pulling unit Z4 which follows the pulling unit Z3 in the web running direction, for the purpose of supplying its lead setpoint value.

The web 1 is printed in a printing press and, after leaving the last printing unit 2, is guided to the folding unit 5 on the path which is shown in simplified form in the figure. In the process, it passes through the pulling unit Z1 which is configured as a cooling unit 3, the pulling unit Z2 ahead of the turning unit 4, the turning unit 4, the pulling unit Z3 after the turning unit 4, and the pulling unit Z4 ahead of the folding unit 5. The web 1 is cross-cut in the cross-cutting device 6, it being necessary to feed the web 1 with the matching cut register. The cut register is controlled by means of the controller 8, the pulling unit Z3 functioning as an actuating element. The actual state of the cut register is determined by means of the cut-register sensor 9 which senses cut-register marks which are printed on the web 1, and passed to the controller 8. The motor 7.3 is changed with regard to its circumferential speed, in accordance with the

deviation from the setpoint value. Furthermore, the actual value of the cut register is determined by means of the cut-register sensor 10 at a web section which lies ahead of the pulling unit Z3, and a
5 differentiating proportion is fed to the controller 8 in order to subject the latter to feedforward control. Furthermore, the actuating intervention of the controller 8 is used to supply the setpoint value for the lead to the pulling unit Z4. For the case where
10 further pulling units are situated after the pulling unit Z3 in the web running direction, the actuating intervention of the control circuit 8 can also be used for these, in order to supply setpoint values for the leads.

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The controller 8 can also be subjected to feedforward control in such a way that the actual state of the cut register is determined without sensors by means of a mathematical model and a differentiating proportion is
20 derived and used for the feedforward control of the controller 8. This variant is shown in the figure using thin lines and with the number 11 in brackets. Measured values, for example the lead of the cooling unit 3, the web tension on the threading unit and
25 optionally other and further measured values, are fed to the computing and storage unit 11, from which measured values the actual state of the cut-register error is calculated using the mathematical model.

30 Furthermore, the control algorithm of the controller 8 comprises a mathematical model in such a way that the forces of the web 1 which have a retroactive effect on the torque of the motor which corrects the cut register are compensated for to a very large extent.

List of reference numerals

- 1 Web
- 2 Printing unit
- 3 Cooling unit
- 4 Turning unit
- 5 Folding unit
- 6 Cross-cutting device
- 7.1 Motor
- 7.2 Motor
- 7.3 Motor
- 7.4 Motor
- 8 Controller
- 9 Cut-register sensor
- 10 Cut-register sensor
- 11 Computer and storage unit

- Z1 Pulling unit
- Z2 Pulling unit
- Z3 Pulling unit
- Z4 Pulling unit